

Date: Monday, 07/07/2008 4:23:34 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HANDLE ASSEMBLY (EXTERIOR) *Sheet*
 Job Number : 40348 -1
 Estimate Number : 13371
 P.O. Number :
 This Issue : 07/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 05032
 Written By :
 Checked & Approved By : JUD 08.7.07
 Comment : Est Rev:A 08-06-09 new issue DD verified by:ec

Part Number : D3779041
 Drawing Number : D3779 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 28/07/2008 Qty: 13 Um: 10 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.2037 sf(s)/Unit Total : 2.0370 sf(s)
 6061-T6 .125 Sheet
 batch: 106634 IB 8-7-14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3779
 Dwg Rev: A
 Prog Rev: A

IB 8-7-14

14

2-Deburr if necessary

IB 8-7-14

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

0061215 (+14)

PRO

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

Dart Aerospace Ltd

W/O: 40348		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/07/21	4.1	countersink de burr	FF	08/07/23	14		
	4.2	QC 5		08/07/25	144		
	4.3	Chemical Conversion Coat	FL	08/07/25			
	4.4	QC 3		08/07/25	148		

Part No: D3779-041 PAR #: N/A Fault Category: Prod Eng Coordinating NCR: Yes No: No DQA: D Date: 08/10/23
 (D412-658-035) QA: N/C Closed: 14 Date: 08/10/24

NCR: 40348		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/15	# 4.0	During QC inspection it was found that the distance between the $\phi.315$ - $\phi.323$ holes Dist. 6.460" measure 7.00"	08/07/15	update draw water set AND Program according to Dwg. Revised <u>08/07/15</u>	08/07/15	08/07/15	08/07/15	08/07/15
		Ensure Employee verifies measurement. Holes are 0.040" off	08/07/15		08/07/15	08/07/15	08/07/15	08/07/15
		EL Program on water set was not not updated to the Dwg. D3779-1. Operator took Program from Prod	08/07/15	Scan and Destroy and replace QTY 1.14 B# M166634	08/07/15	08/07/15	08/07/15	08/07/15

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:23:35 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY (EXTERIOR)

Job Number: 40348

Part Number: D3779041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Handle

batch:

40353

Resh/28 (11)

7.0

MS20426AD10 18

Rivet Countersunk



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet Countersunk

batch:

M107936

448

or (MS20426AD10-10)

B

D3779-041
3 stock

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

M08/07/21

1- counter sink holes as per dwg D3779

2- deburr

3- rivet D3203-1 handle to D3779-1 plate as per dwg D3779 per QSI003

FF 08/10/22

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S08/10/22 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location:

Resh/23 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23

Job Completion



MF 08-10-23

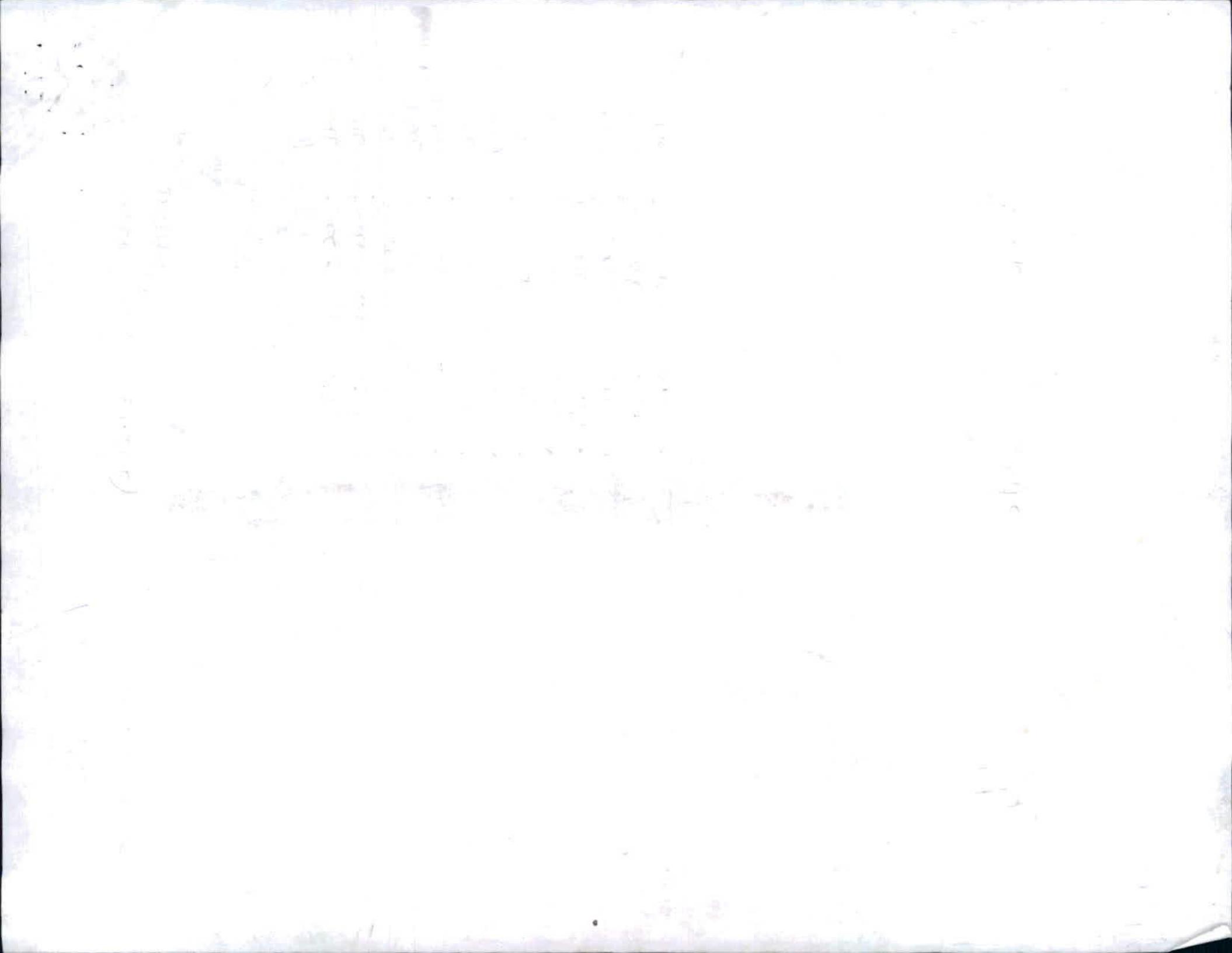
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

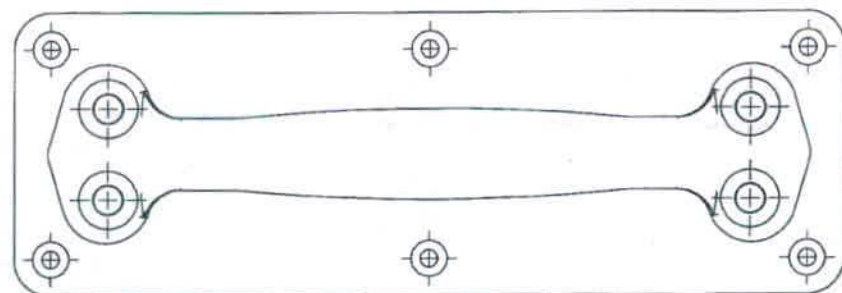
NOTE: Date & initial all entries



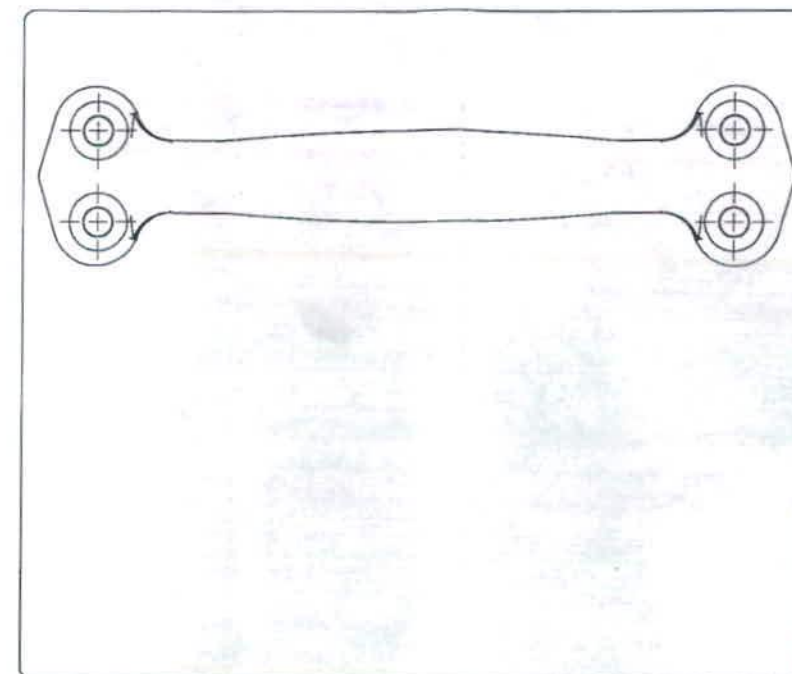
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D

D



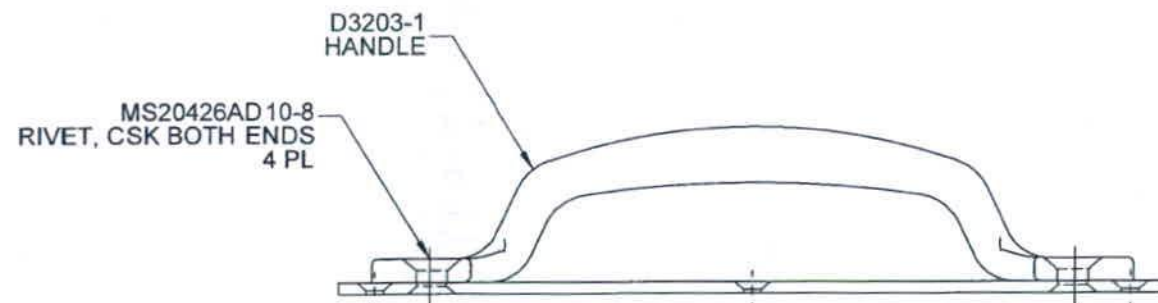
D3779-1
PLATE



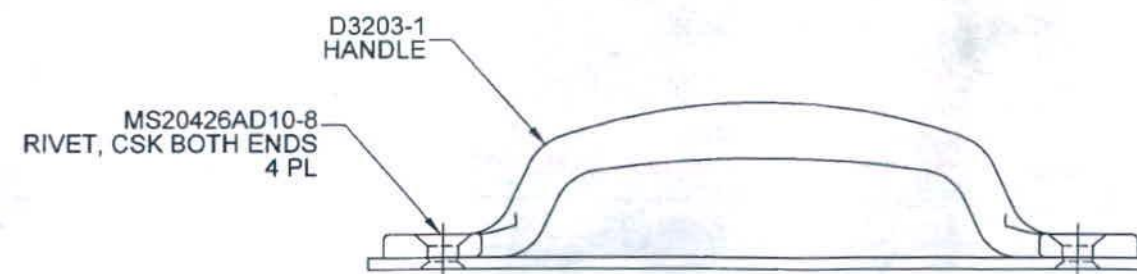
D3779-5
PLATE

C

C



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

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NO. 40348

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08.06.26 1/1

NOTES:

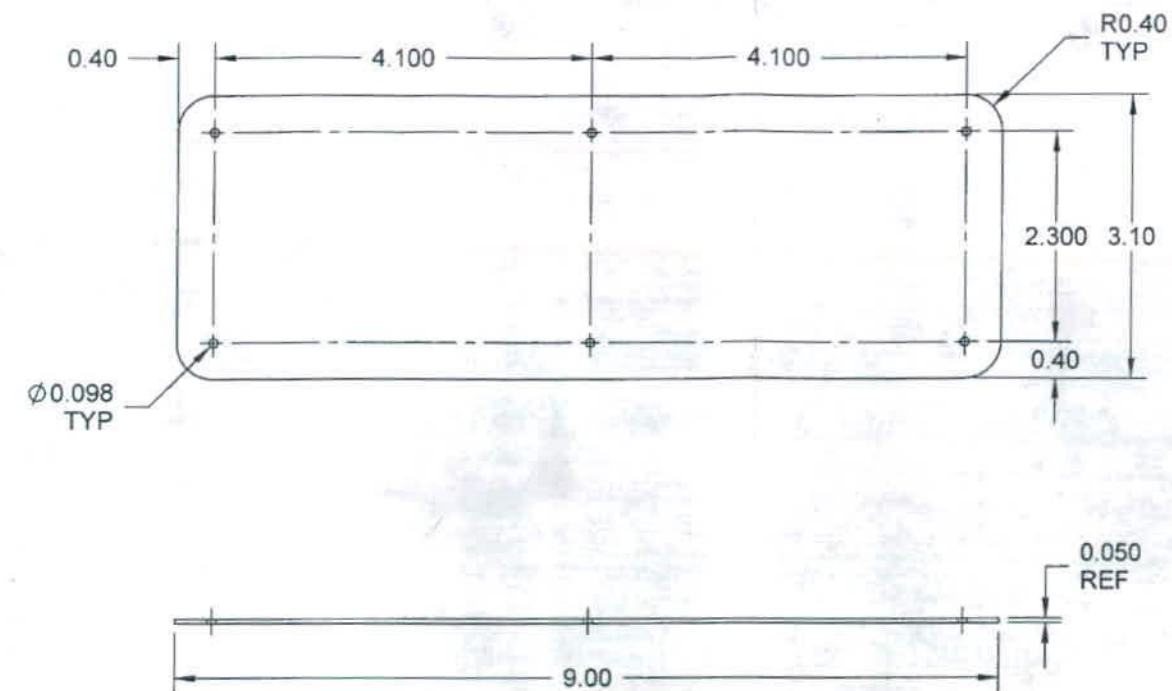
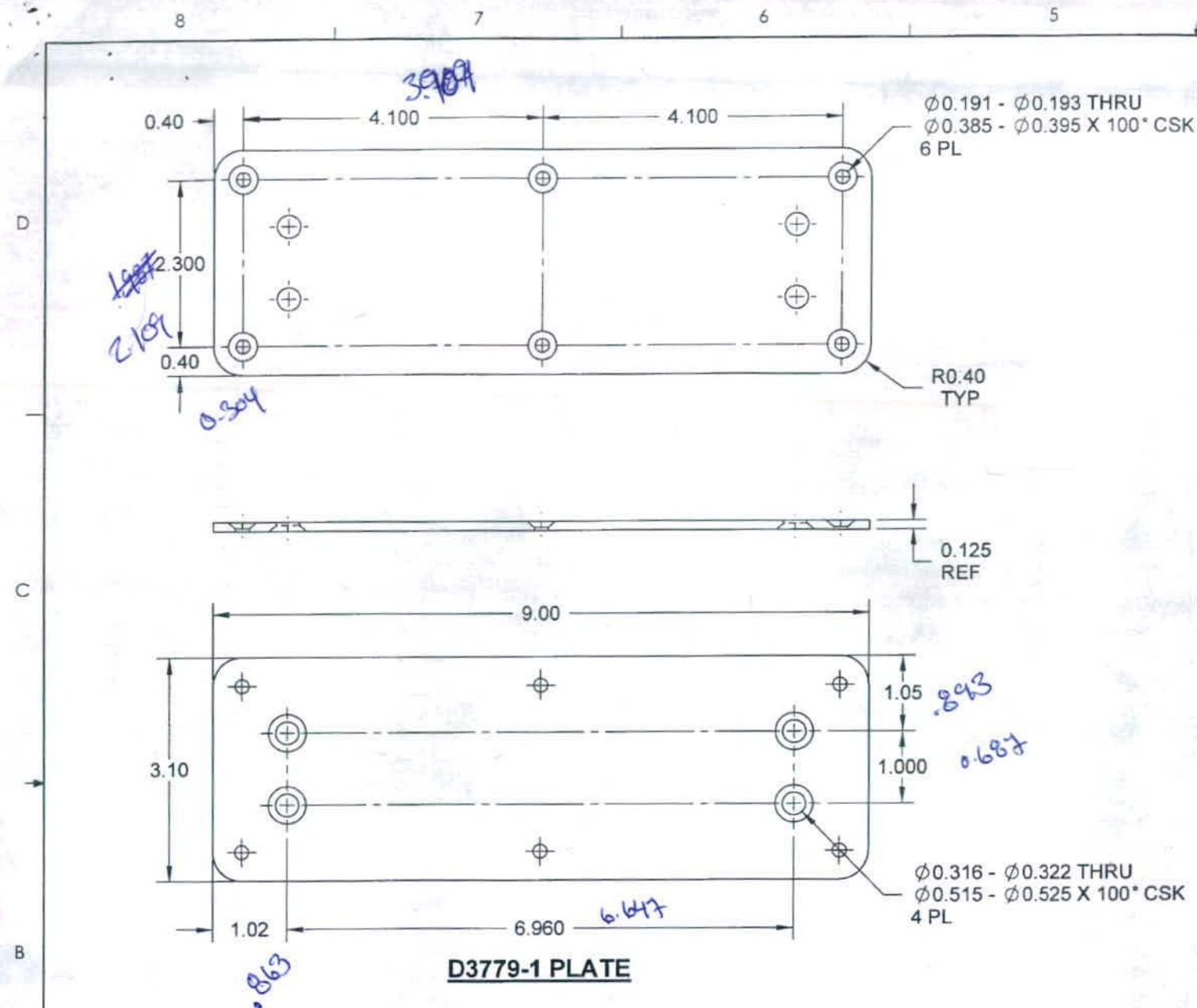
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

A

A

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 2 OF 4
APPROVED		TITLE	HANDLE ASSEMBLY, SCALE
DE APPR.		CABIN SLIDING DOOR	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



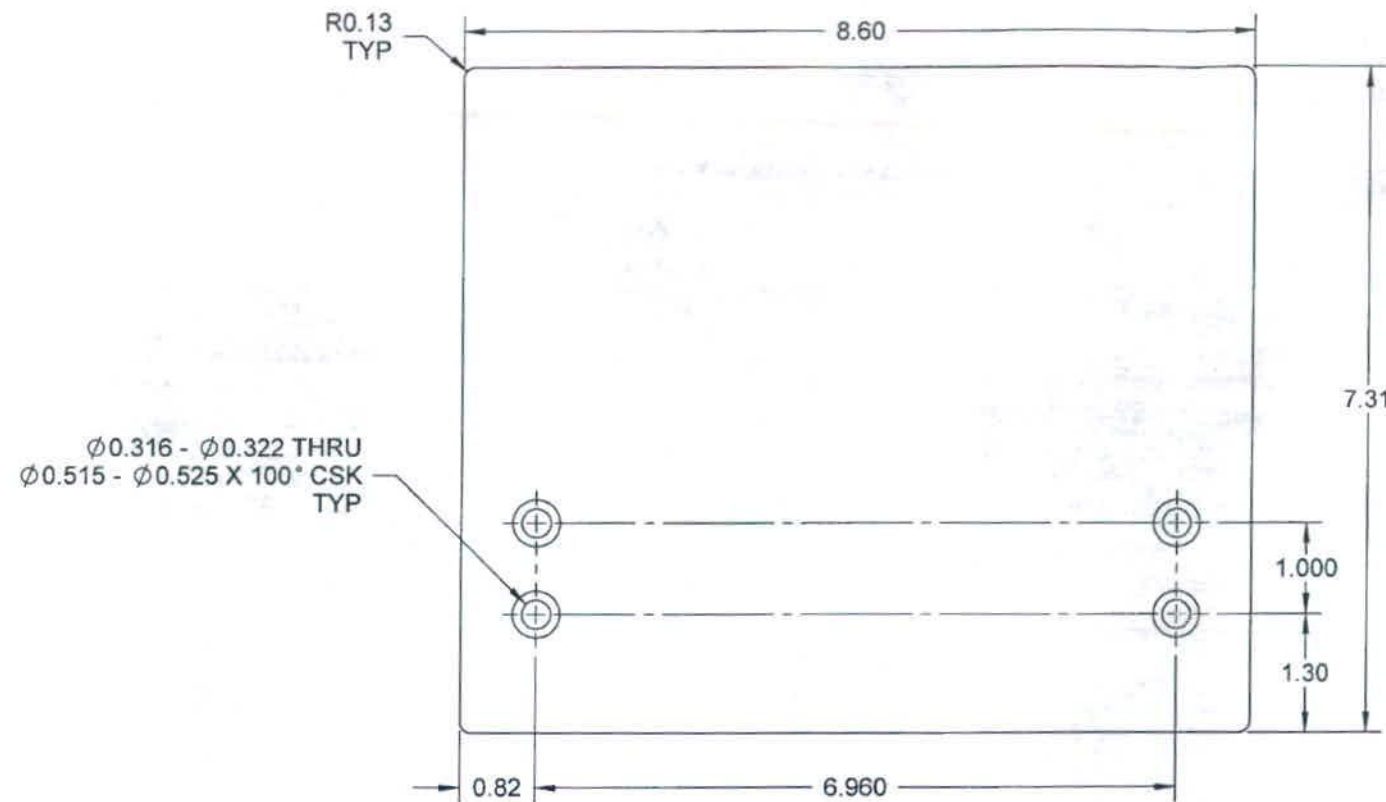
NOTES:

- 1) MATERIAL: -1 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125
-3 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER
(DO NOT IDENTIFY -1 & -5)
- 7) WEIGHT: 0.14 lbs FOR -3.

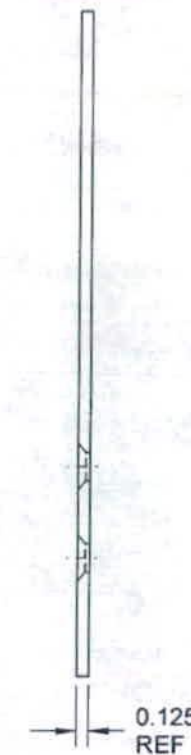
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MFG. APPR.		D3779	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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D3779-5 PLATE



NOTES:

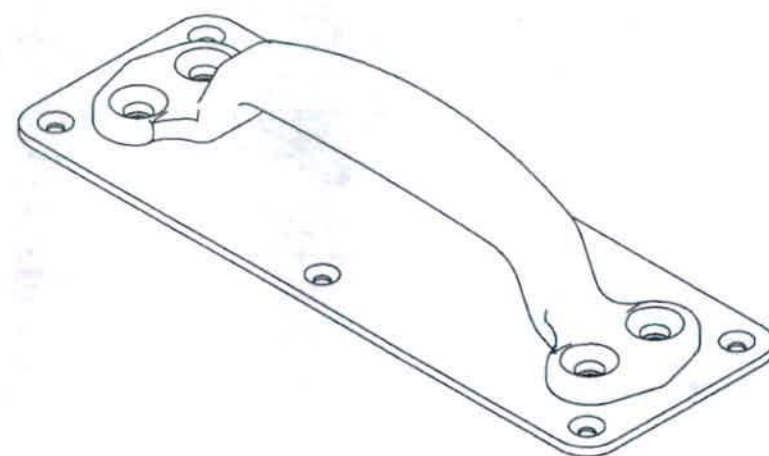
- 1) MATERIAL: -5 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

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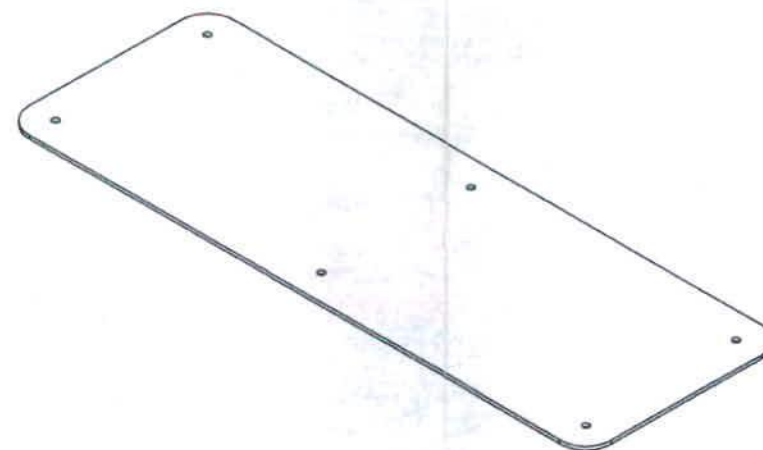
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MFG. APPR.		SHEET 4 OF 4	
APPROVED		TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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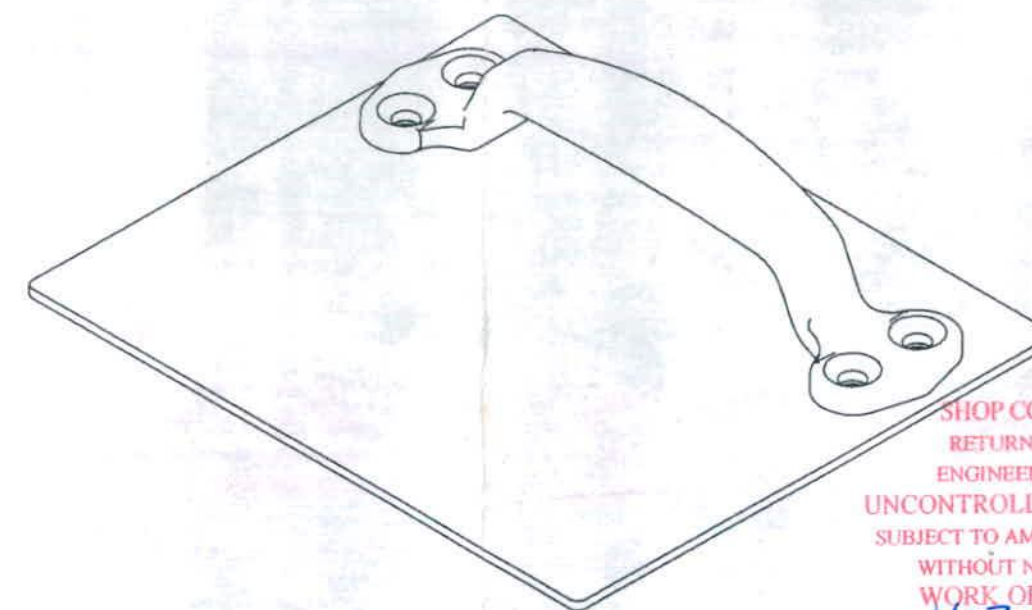
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-3 DOUBLER PLATE



D3779-043 HANDLE ASSEMBLY
(INTERIOR)

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08-06-26 MP

A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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